

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item ID:	D3562-042	Accept		Setup	Start	
Revision ID:						
Item Name:	Step Assembly, RH				Stop	
Start Date:	12/23/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/05/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	M-L	10/01/04	(18)				
140  Small Fab Small Fab	Small Fab Memo 1- Drill Rivet holes as per dwg D3562. Touch up alodine 2- Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnobond ***** □A/R Magnabond 6398 Batch: <u>m112417</u>	0.00 0.00		10-01-04					
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	58	10/01/04	(4)				

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NOTE: Date & initial all entries

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Item ID: D3562-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Assembly, RH

Start Date: 12/23/09 Start Qty: 1.00

Cust Item ID:

Required Date: 1/05/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as
per QSI 024. ☐ A/RAluminum Rod 11/13/11 ☐ 2-Grind end cap welds flush
as per Dwg D3562

10.01.04

170

0.00

QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

Quality Control

10.01.04

180

0.00

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*278 10/01/05**(124)*

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Item ID:	D3562-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, RH					
Start Date:	12/23/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/05/10	Req'd Qty:	1.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		=> M 10/01/05		(X) RH			
200 Powdercoat Powder Coating	* PRESSURE WASH White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum N 113170 Memo START TIME: 8:30AM F OVEN TEMPERATURE: 9:00AM FINISH TIME: 3:20PM	0.00 0.00		=> M 10/01/05		(X) S			
210 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo 10/01/05 WING WALK. BATH M112900	0.00 0.00		BR 10-01-5		D			

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Item ID: D3562-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 12/23/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

27 5 10/01/05



230

Identify as per dwg & Stock Location: *PR*

0.00



Packaging

Memo

0.00

Packaging

10-1-5 SL



240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-01-05

WLF 10-01-05

Picklist Print

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Work Order ID: 54848



Parent Item: D3562-042



Parent Item Name: Step Assembly, RH

Start Date: 12/23/09

Required Date: 1/05/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2622-120C

Manufactured

No

140

Each

85.8200

1.0000



Step Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

85.82

48612

3.12

52026

82.7

D2734

Manufactured

No

100

Each

27.0000

2.0000



Step End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

43535

2

48110

25

D3560-042

Manufactured

No

140

Each

3.0000

1.0000



Arm Weldment

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

~~348386~~ 348386 3

47864

3

10.01.04

10.01.04

10.01.04

1

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 54848



Parent Item: D3562-042



Parent Item Name: Step Assembly, RH

Start Date: 12/23/09

Required Date: 1/05/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3560-044 Arm Weldment		Manufactured	No			140	Each	5.0000	1.0000			

10.01.04

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST *348388*

5

46403

1

47866

4

MS20600-AD4W5

Purchased

No

160

Each

884.0000

32.0000



Blind Rivet

10.01.04

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

884

110523

212

111477

672

32

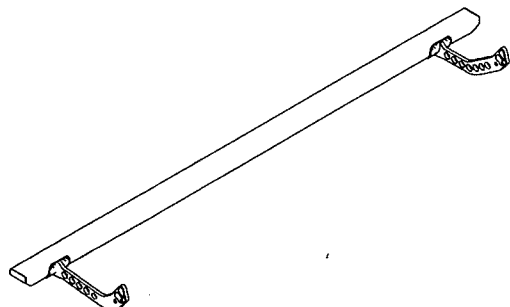
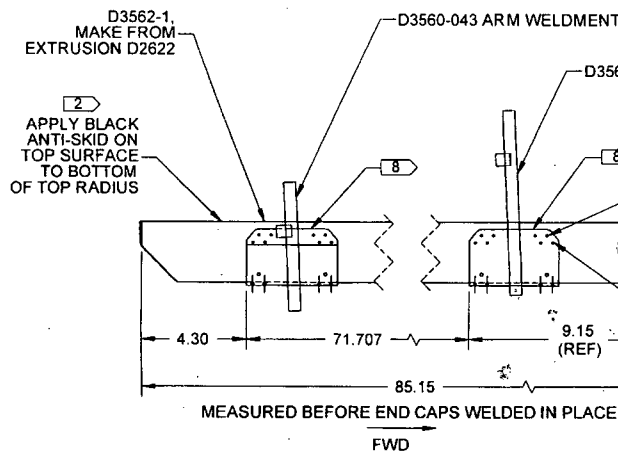
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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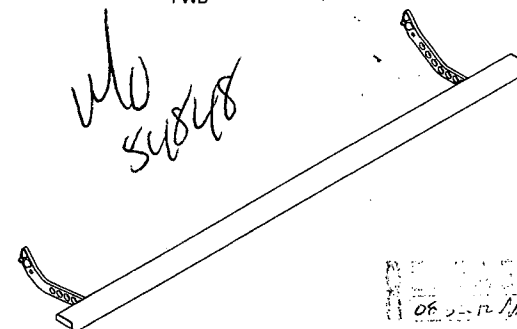
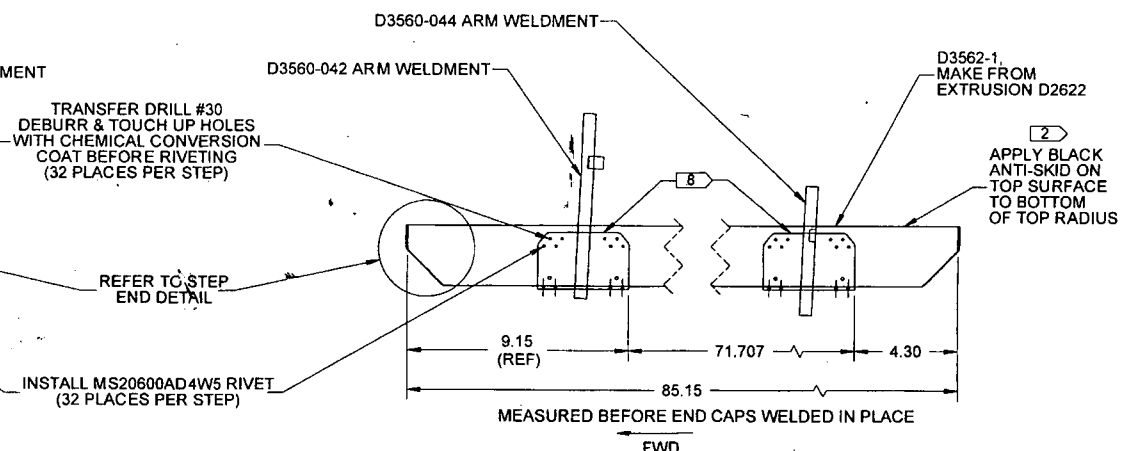
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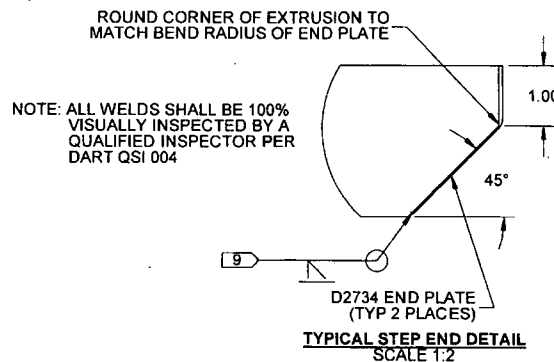


D3562-041 LH STEP ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6) OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.4
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 8.79 lbs
 - 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
 - 9) WELDING: PER DART QSI 004



D3562-042 RH STEP ASSEMBLY



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
1	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	9P		
DRAWN	64		
CHECKED	IE		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
DRAWING NO. D3562	SHEET 1 OF 1
TITLE STEP ASSEMBLY	SCALE 1:5

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